



插销螺套 · 钻头与丝锥参数表

METRIC KEY-LOCKING INSERTS | INSTALLATION REFERENCE

本表为公制插销螺套的安装孔参考数据，单位 mm。按轻型与重型分别列示；同一内螺纹规格可能对应不同外螺纹和钻孔尺寸，不可只按内螺纹选钻头。

Metric key-locking insert installation references, in mm. Lightweight and heavy-duty series are separate: the same internal thread may need different external threads and hole sizes.

攻丝规格对应螺套外螺纹，安装孔螺纹等级为 6H。不得使用钢丝螺套的 STI 参数或仅按内螺纹规格攻丝。孔加工前须确认螺套外形、母材、工具和图纸。

The installation tap matches the external thread; the tapped hole is class 6H. Do not use wire-insert STI data or tap to the insert internal thread. Confirm the insert, material, tooling and drawing.

长度 L 公差为 ± 0.3 mm；沉孔直径公差为 $+0.25 / -0.00$ mm。本表所列最小深度是攻丝深度，不是钻孔总深度；钻尖、丝锥导入段与盲孔底部余量另行核定。钻孔直径公差及沉孔角度按确认图纸执行。

L tolerance: ± 0.3 mm. Countersink diameter: $+0.25 / -0.00$ mm. Minimum tapping depth is not total drilling depth. Allow separately for drill point, tap lead and blind-hole clearance; drill tolerance and countersink angle follow the approved drawing.

本表标准型与锁紧型合并列出，仅因来源目录中所列安装字段一致。内螺纹锁紧结构、锁紧段长度、承载及扭矩要求不在本表范围内，不能据此认定两者可互换。

Standard and locking variants share the listed installation fields in the source, so these fields are combined. Locking geometry, locking-zone length, load and torque are excluded; interchangeability is not implied.

本次列出轻型 M5 至 M12、重型 M4 至 M24，共 28 组已取得的公制组合。未列规格、英制及其他系列不插值、不推算，也不代表秩成供货范围。

Coverage: 8 lightweight and 20 heavy-duty metric combinations. Unlisted sizes, inch series and other families are not extrapolated. Listed dimensions do not establish ZCOIL supply availability.

底孔、攻丝、沉孔与拆卸钻孔为不同工序。本表仅保留安装字段，不把拆卸钻孔尺寸当作安装底孔。较硬母材的锁键槽准备和安装工艺需单独确认。

Installation drilling and removal drilling serve different purposes. Only installation fields are included here. Confirm key-slot preparation and installation requirements for hard parent materials.

版本 ZC-KL-20261001-R1。本版依公开官方目录的安装尺寸重新整理；尚未完成秩成产品适配验证。加工以双方确认图纸为准。

ZC-KL-20261001-R1. Reorganized from a public official catalogue. ZCOIL product compatibility is not verified. Approved drawings govern machining.

公制轻型 · 安装孔参数

Metric lightweight | mm | Standard & locking | Ref. p.14

螺套内螺纹 Internal thread	螺套外螺纹 External thread	长度 L ±0.3 Length L +/-0.3	安装底孔 Ø Tap drill Ø	沉孔 Ø +0.25/-0.00 Countersink Ø +0.25/-0.00	攻丝规格 6H Installation tap 6H	最小攻丝深度 Min tapping depth
M5X0.8	M8X1.25	8.0	6.9	8.25	M8X1.25	9.5
M6X1.0	M10X1.25	10.0	8.8	10.25	M10X1.25	11.5
M8X1.25	M12X1.25	12.0	10.8	12.25	M12X1.25	13.5
M8X1.0	M12X1.25	12.0	10.8	12.25	M12X1.25	13.5
M10X1.5	M14X1.5	14.0	12.8	14.25	M14X1.5	15.5
M10X1.25	M14X1.5	14.0	12.8	14.25	M14X1.5	15.5
M12X1.75	M16X1.5	16.0	14.75	16.25	M16X1.5	17.5
M12X1.25	M16X1.5	16.0	14.75	16.25	M16X1.5	17.5

先确认内螺纹与结构系列，再核对外螺纹、底孔和攻丝。安装孔为 6H；孔加工总深度另行核定。
Match the series and external thread before selecting the drill and tap. Minimum tapping depth is not total drill depth.

公制重型 · 安装孔参数

Metric heavy-duty | mm | Standard & locking | Ref. p.15

螺套内螺纹 Internal thread	螺套外螺纹 External thread	长度 L ±0.3 Length L +/-0.3	安装底孔 Ø Tap drill Ø	沉孔 Ø +0.25/-0.00 Countersink Ø +0.25/-0.00	攻丝规格 6H Installation tap 6H	最小攻丝深度 Min tapping depth
M4X0.7	M8X1.25	8.0	6.9	8.25	M8X1.25	9.5
M5X0.8	M10X1.25	10.0	8.8	10.25	M10X1.25	12.5
M6X1.0	M12X1.25	12.0	10.8	12.25	M12X1.25	14.5
M8X1.25	M14X1.5	14.0	12.8	14.25	M14X1.5	16.5
M8X1.0	M14X1.5	14.0	12.8	14.25	M14X1.5	16.5
M10X1.5	M16X1.5	16.0	14.75	16.25	M16X1.5	18.5
M10X1.25	M16X1.5	16.0	14.75	16.25	M16X1.5	18.5
M12X1.75	M18X1.5	18.0	16.75	18.25	M18X1.5	20.5
M12X1.5	M18X1.5	18.0	16.75	18.25	M18X1.5	20.5
M12X1.25	M18X1.5	18.0	16.75	18.25	M18X1.5	20.5
M14X2.0	M20X1.5	20.0	18.75	20.25	M20X1.5	22.5
M14X1.5	M20X1.5	20.0	18.75	20.25	M20X1.5	22.5
M16X2.0	M22X1.5	22.0	20.50	22.25	M22X1.5	24.5
M16X1.5	M22X1.5	22.0	20.50	22.25	M22X1.5	24.5
M18X1.5	M24X1.5	24.0	22.50	24.25	M24X1.5	26.5
M20X2.5	M30X2.0	30.0	28.00	30.25	M30X2.0	34.5
M20X1.5	M30X2.0	30.0	28.00	30.25	M30X2.0	34.5
M22X1.5	M32X2.0	32.0	30.00	32.25	M32X2.0	36.5
M24X3.0	M33X2.0	33.0	31.00	33.25	M33X2.0	37.5
M24X2.0	M33X2.0	33.0	31.00	33.25	M33X2.0	37.5

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Match the series and external thread before selecting the drill and tap. Minimum tapping depth is not total drill depth.